DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-024332
Date Inspected: 11-Jun-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Li Yang

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Trial Assembly

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Cable Bracket at Bay # 19

This QA Inspector performed Dimension Control Inspection to check and measure the flatness at Cable Brackets Plates connecting Deck Panel, Edge Panel and Side Panel. The following Cable Brackets were inspected and observed flatness within the allowable tolerances.

SA6529

The result of Inspection was informed to the Caltrans Lead Inspector Mr. Hiranch Patel and Mr. Mark Miller for further review and disposition.

Please reference the pictures attached for more comprehensive details.

Cross Beam (CB) # 18

This QA Inspector performed Dimension Control Inspection for measuring offset between the stiffeners at the following locations.

At Floor Beam (FL3) extension at Segment 13AE to Cross Beam # 18 stiffeners.

At Panel Point (PP) 118, Segment 13AE offset measurement performed between Floor Beam (FL3) stiffeners to west side Vertical Web Plate stiffeners of cross beam # 18 total 13 stiffeners.

At Panel Point (PP) 119 (-1500), Segment 13AE offset measurement performed between Floor Beam (FL3) stiffeners to west side Vertical Web Plate stiffeners of cross beam # 18 total 13 stiffeners.

At Panel Point (PP) 119, Segment 13AE offset measurement performed between Floor Beam (FL3) stiffeners to west side Vertical Web Plate stiffeners of cross beam # 18 total 13 stiffeners.

At Deck Panel extension at Segment 13AE to Cross Beam # 18 stiffeners.

Between Panel Point (PP) 118 to PP 119 (-1500), Segment 13AE offset measurement performed between Deck Panel (FL3) stiffeners to Deck Panel stiffeners of cross beam # 18 total 7 stiffeners.

Between Panel Point (PP) 119 (-1500) to 118, Segment 13AE offset measurement performed between Deck Panel (FL3) stiffeners to Deck Panel stiffeners of cross beam # 18 total 3 stiffeners.

At Bottom Panel extension at Segment 13AE to Cross Beam # 18 stiffeners.

Between Panel Point (PP) 118 to PP 119 (-1500), Segment 13AE offset measurement performed between Bottom Plate stiffeners to Bottom Panel stiffeners of cross beam # 18 total 7 stiffeners.

Between Panel Point (PP) 119 (-1500) to 118, Segment 13AE offset measurement performed between Bottom Plate stiffeners to Bottom Panel stiffeners of cross beam # 18 total 3 stiffeners.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 13AE (Floor Beam to Flange)

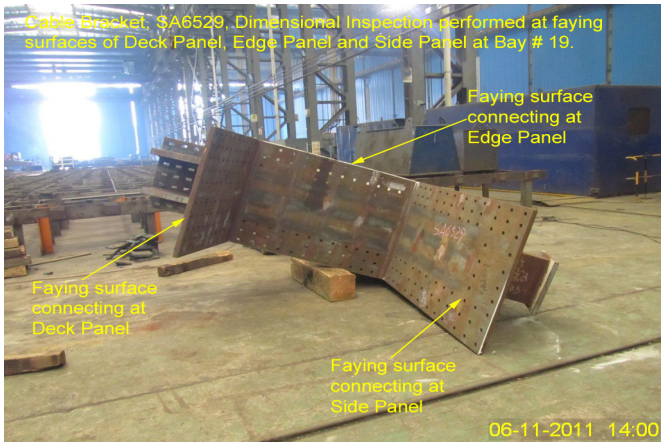
This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) weld. The weld joint was designated as FB3125-001-178. The welder identification was 054467 and observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-B-P-2212-Tc-U4b-FCM-1. The piece mark was identified as weld connecting the Floor Beam FL3 to the Bottom Plate Flange at PP 119(-1500).

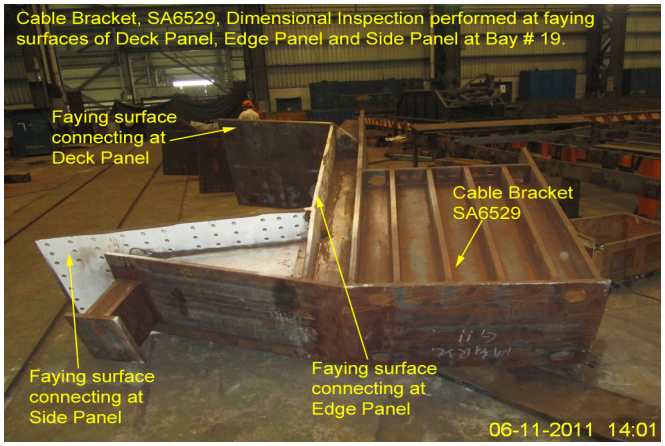
Please reference the pictures attached for more comprehensive details.

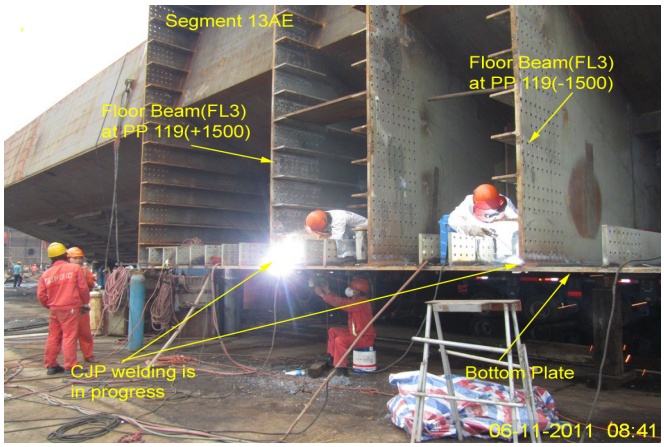
Segment 13AE (Floor Beam to Flange)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) weld. The weld joint was designated as FB3122-001-188. The welder identification was 215248 and observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-B-P-2212-Tc-U4b-FCM-1. The piece mark was identified as weld connecting the Floor Beam FL3 to the Bottom Plate Flange at PP 119(+1500).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.







Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer